

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008580**Date Inspected:** 25-Jul-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** ZPMC and ABF**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. Wai Pau, was present during the times noted above for observations relative to the work being performed.

**Bay #10 South and North Tower Shop**

South Tower Lift #3:- Caltrans QA inspector observed three ZPMC welding operators performed semi-automatic SAW on outer corner longitudinal seam weld that connected skin plate B to C of south tower lift #3. The semi-automatic SAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

North tower lift #3:- Caltrans QA Inspector observed two welders performed FCAW process on outer corner longitudinal seam weld that connected skin plate B to C. The FCAW welding is one meter length areas are located two roller installing surface. The FCAW was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

**Bay #11 South and North Tower Shop**

West Tower Lift #3:- Caltrans QA Inspector observed eight welders performed FCAW process on inner corner longitudinal seam weld that connected skin plate C to D and D to E. The FCAW welding located at elevation 89m to 111.67m diaphragm section. The FCAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QA inspector observations, no discrepancies were noted.

East Tower Lift #3:- Caltrans QA Inspector observed three welders performed FCAW process on outer corner longitudinal seam weld that connected skin plate C to D. The FCAW welding located at elevation 8 99m and 105.5m diaphragm section. The FCAW welding was monitored and recorded by ZPMC and ABF QC inspector. Based

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## WELDING INSPECTION REPORT

( Continued Page 2 of 2 )

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on Caltrans QA inspector observations, no discrepancies were noted.

West Tower lift#2:- Caltrans QA Inspector observed six ZPMC grinders in process of grinding process on fit lugs. The fit lug located at the elevation 53m to 80.75m diaphragm sections that connected skin plate A and B of west tower lift #2. The grinding process was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

West Tower lift#1:- Caltrans QA Inspector observed four ZPMC grinders and two welders in process of grinding process and FCAW repair welding on diagonal stiffeners. The diagonal stiffeners located at the elevation 9m to 47.6m diaphragm sections that connected skin plate B, C and D of west tower lift #1. The grinding process and FCAW repair welding was monitored and recorded by ZPMC and ABF QC inspector. Based on Caltrans QAI observations, no discrepancies were noted.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

As notes within report above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinoved 13482570045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Pau,Wai	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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